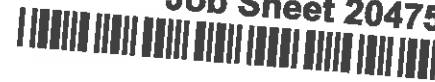




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200
Fax 613 632-5246

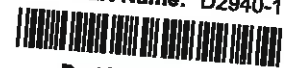
DSK081
Job Sheet 204759



Part No: DSK081

Part Name: D2940-1 Turning Detail

Job Qty: 8 pcs



Part Weight: 0 lbs

Job Created: 12/18/19

Due Date: 2/3/20

Type: Stock

Status: New

Job Tracking No:

Priority: Medium

Created By: Marie Lajeunesse

Description:

Note: DWG REV B IPP rev A. 08.03.13 new issue EC

Ship Via:

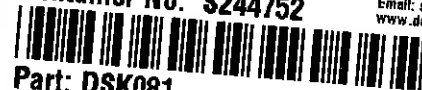
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	8 pcs					Doosan - 1		
110	QC 2	8 pcs					QC 2 - 1		
				2/3/20	0.20	9.09	QC 2 - 12		
				2/3/20	0.00	0.00	QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S244752



Part: DSK081

Job No: 204759

Serial No/Batch: S244752

Revision:

Inspector:

Exp Date:

Instructions:

Date: 01/04/20

120	QC 8	8 pcs	2/3/20	0.00	0.00	QC 2 - 5	
						QC 2 - 71	
						QC 2 - 73	
						QC 2 - 69	
						QC 8 - 12	
						QC 8 - 14	✓ 20/01/04
						QC 8 - 17	
						QC 8 - 20	
						QC 8 - 25	
						QC 8 - 3	
						QC 8 - 32	
						QC 8 - 33	
						QC 8 - 35	
						QC 8 - 39	
						QC 8 - 4	
						QC 8 - 44	
						QC 8 - 45	
						QC 8 - 49	
						QC 8 - 58	
						QC 8 - 8	
						QC 8 - 9	
						QC 8 - 68	
						QC 8 - 67	
						QC 8 - 1 (A)	
						QC 8 - 47	
						QC 8 - 40	
						QC 8 - 52	
						QC 8 - 23	
						QC 8 - 57	
						QC 8 - 76	
						QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	8 pcs	2/3/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	✓ 20/01/04
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	

					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140	QC 21 - SA	8 pcs	2/3/20	0.00 0.00	QC 21 - SA - 21	248
					QC 21 - SA - 70	21
					QC 21 - SA - 53	3.88
Part Op 100 - (Doosan Lathe) Turn blank as per Folio FA079 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB) 120 - (QC8- Inspect parts - second check) 130 - (Identify as per dwg & Stock Location: <u>MATOLD</u>) LOCATION: MAT060 140 - (QC21- Final Inspection - Work Order Release) JAN 16 2020						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
D6104-007	Round Billet, 17-4	8 pcs (1 ea)	100-Doosan - 1	S235964 x6		
				S173161 x2		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
100-Doosan - 1	D6104-007	8	20	0		
Part Specifications						
Specifications could not be found.						

Plex 12/18/19 1:54 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	204759
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	3.211	3.216	DT 8489	3.216	3.216	3.215	3.215	3.216
B	4.946	4.966	L	4.956	4.956	4.956	4.956	4.956
C	0.718	0.738		.730	.729	.730	.730	.730
D	0.090	0.110		.105	.100	.100	.100	.100
E	3.564	3.584		3.573	3.574	3.574	3.574	3.574
F	0.022	0.042		R1/32	R1/32	R1/32	R1/32	R1/32
G	3.444	3.464		3.452	3.452	3.454	3.4535	3.4535
H	0.112	0.132		.125	.118	.119	.119	.119
I	2.170	2.190		2.18	2.18	2.18	2.18	2.18
J	4.451	4.471		4.46	4.463	4.46	4.4625	4.463
K	0.413	0.433		.423	.425	.425	.425	.425
L	0.913	0.933		.923	.920	.920	.920	.920
M								
N								
O								
P								

Measured by:		Date:	20/01/04
Audited by:		Date:	20/01/04
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order:	204759
Description: Turning Detail for D2940-1		Part Number:	DSK081
Inspection Dwg: DSK081 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6	7	8	9	5
Lathe Section								
A	3.211	3.216		3.2160	3.2160	3.2160		
B	4.946	4.966		4.956	4.956	4.956		
C	0.718	0.738		0.730	0.730	0.730		
D	0.090	0.110		0.100	0.100	0.100		
E	3.564	3.584		3.574	3.574	3.574		
F	0.022	0.042		0.032	0.032	0.032		
G	3.444	3.464		3.454	3.454	3.454		
H	0.112	0.132		0.119	0.119	0.119		
I	2.170	2.190		2.180	2.180	2.180		
J	4.451	4.471		4.459	4.461	4.460		
K	0.413	0.433		0.425	0.425	0.425		
L	0.913	0.933		0.920	0.920	0.920		
M								
N								
O								
P								

Measured by:		Date:	20/01/04
Audited by:		Date:	20/01/04
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

